

Work Order ID 86977

86977

Page 1

July-10-12 9:12:05 AM

Item ID: D3026-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Channel

Start Date: 7/10/12 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 2.00 *2*

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MLJ Date: 12/07/11 Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3026	C								

100 0.00

100 FLOW WATER JET 0.00

Waterjet Memo 0.00

FLOW CNC Waterjet 1-Cut as per Dwg D3026

2024.050 Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110 0.00

QC Memo

Quality Control

1312-7-24

1312-7-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Channel

Start Date: 7/10/12

Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Form as per dwg

0.00

130

Brake NC

NC BRAKE

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

smB
12-7-24

DAS
16
2-83

12/4/25

5

5

(B)

8

12/6/25

W/O:		WORK ORDER CHANGES					
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Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

Memo

0.00

HandFinish

Hand Finishing

160

QC3- Inspect Part Finish

0.00

160

Memo

0.00

QC

Quality Control

170

Identify as per dwg & Stock Location

0.00

170

Memo

0.00

Packaging

Packaging

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Stop ***NS2***

Item Name: Channel

Start Date: 7/10/12

Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00


180

QC

Memo

0.00

Quality Control

12/17/31 

MLJ 12/07/30

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

July-10-12 9:12:04 AM

Page 1

Work Order ID: 86977

Parent Item: D3026-1

Parent Item Name: Channel

Start Date: 7/10/12

Required Date: 8/10/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP D05.10.07Added forming step and Issue P/OKJ/JLM
IPP E 07.01.04 waterjet ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050 2024-T3 .050 sheet		Purchased	No			100	sf	253.5000	0.64	1.3473684	3.5	12-7-24	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT022	253.5						
						117684	22.8						
						121216	89.2						
						121889	141.5						

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Dart Aerospace Ltd

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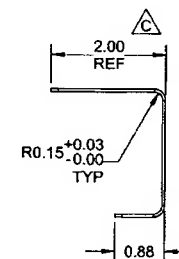
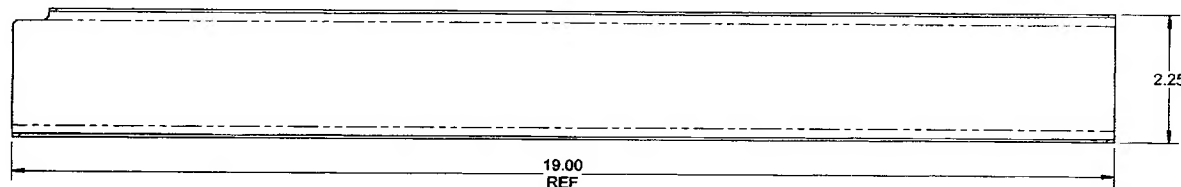
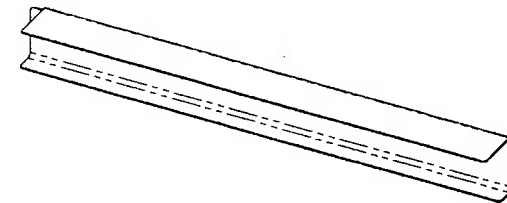
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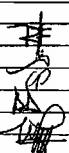
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO. 86977 MCLJ
12/07/11



D3026-1 CHANNEL

RELEASED
 2011-05-26

C	FORMAT TO CURRENT STD; 2.00 REF WAS 0.88 (C2-1); UPDATED FLAT PATTERN; 4.87 WAS 3.740 (C8-2); REF. PAR11-104/NCR11-574.	MB	11.05.13
B	REMOVE HOLES	CP	05.09.20
A	NEW ISSUE	RF	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D3026 REV. C	
CHECKED		SHEET 1 OF 2	
MFG. APPR.		TITLE CHANNEL SCALE	
APPROVED		NTS	
DE APPR.		COPYRIGHT © 2011 BY DART AEROSPACE LTD	
DATE	11.05.13	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

- NOTES:**
- 1) MATERIAL: MAKE FROM D3026-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: 0.46 lbs

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

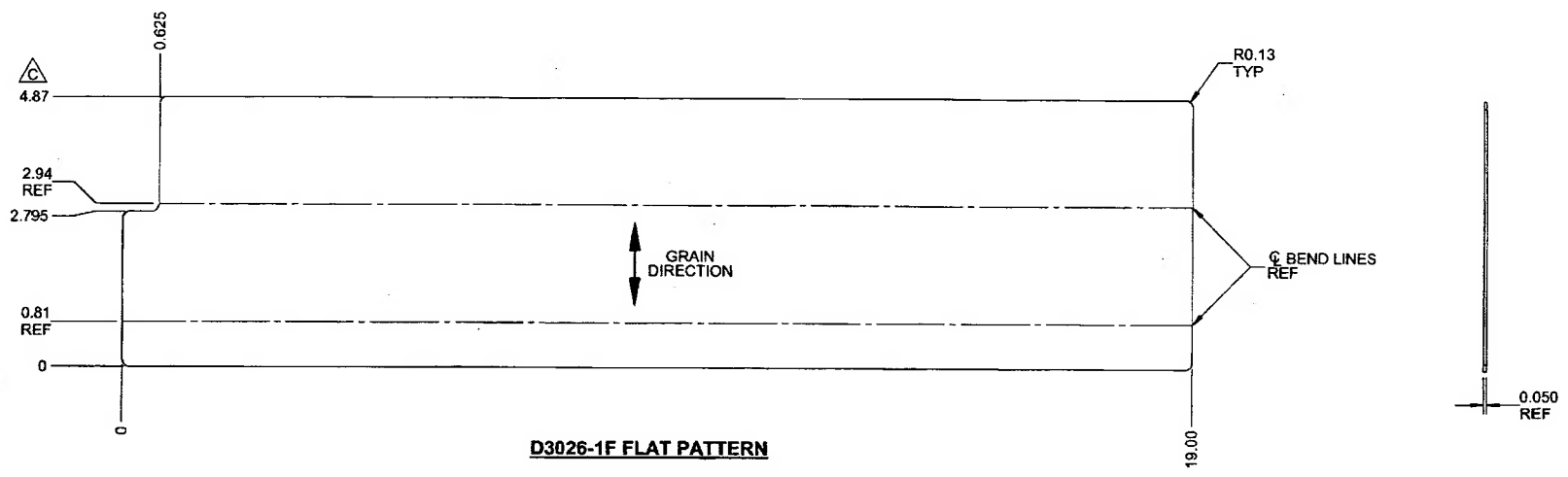
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8 7 6 5 4 3 2 1

86977



D3026-1F FLAT PATTERN

RELEASED
2011-05-24
MND

- NOTES:**
 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
 PER QQ-A-250/4 OR AMS-QQ-A-250/4
 OR AMS 4037
 OR ASTM B209
 REF DART SPEC M2024T3S.050
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.46 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3026	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CHANNEL	NTS
DATE	11.05.13	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

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